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D4018-041
Job Sheet 195020



Part No: D4018-041

Job Qty: 1 pcs

Part Name: AS350 Short Basket Lid Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/13/19

Job Tracking No:

Due Date: 6/20/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A, D4018 REV E SHEETS 1,2,3 IPP RevA: new issue DD 09.11.30 verified by:EC IPP
Rev:B as per dwg revA 10.03.15 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP
Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP REV:E 13.08.21 DWG REV.D / ECN 13-624 DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	6/20/19		0.00	7.69	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
110	QC 9	1 pcs	6/20/19		0.00	0.00	Large Fab - 9		
							QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
120	QC 5	1 pcs	6/20/19		0.00	0.00	QC 9 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
130 Powdercoat - 4 Black Sand B4B <i>14-12-13 158940</i>	1 pcs	6/20/19	0.00 0.42		Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	<i>BR 19-6-4</i>
					Powdercoat - 4 - B4B	
140 Handfinish - 3-1- WingWalk-B4B	1 pcs	6/20/19	0.00 0.88		Handfinish - 3 - 1 - B4B	<i>HL 19-6-4</i>
					Handfinish - 3 - 2 - B4B	
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
150 QC 3	1 pcs	6/20/19	0.00 0.00		QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	<i>DAS</i>
					QC 3 - 30	<i>19</i>
					QC 3 - 34	<i>9-09</i>
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
160 Packaging 3-1 - Stock - B4B	1 pcs	6/20/19	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 -	

				B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
170	QC 21 - SA	1	6/20/19	0.00 0.00	QC 21 - SA - 21
		pcs			QC 21 - SA - 70
					QC 21 - SA - 53
Part Op 100 - (Weld per dwg A/R S.S. rod Batch: <u>138881</u>) 1- assemble ribs , weld as per dwg D4018 using DT9607B 2- weld Descriptions: hinge (3) and Mounting brackets as per dwg D4018 ***inspect before welding mesh*** 3- Cut mesh as per dwg D4020-7 4- tack weld mesh on basket as per dwg D4018 ***make sure to place mesh correctly on lid, check with label plate before tacking mesh*** 110 - (QC9- Inspect visual per QSI004- Fusion Welds) 120 - (QC5- Inspect part completeness to step on W/O) 130 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) *** mask sides of hinge prior to powdercoat*** 140 - (Wing Walk as per dwg QSI005 4.4 Batch _____) 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg 150 - (QC3- Inspect Part Finish) 160 - (Identify as per dwg & Stock Location: _____) 170 - (QC21- Final Inspection - Work Order Release)					

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581 ✓	Mounting Bracket	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S178393
D4016-3 ✓	Hinge Half, Lid	3 pcs (3 ea) ✓	100-Large Fab - Basket - 1	S110937
D4018-1 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S179069
D4018-3 ✓	Rib	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S177108
D4018-5 ✓	Rib	6 pcs (6 ea) ✓	100-Large Fab - Basket - 1	S177390
D4021-3 ✓	Data Plate	1 pcs (1 ea) ✓	100-Large Fab - Basket - 1	S172801
D4035-043 ✓	Lid Rib Assembly, Aft (350 Basket)	2 pcs (2 ea) ✓	100-Large Fab - Basket - 1	S179389
M304EX0.75-16F	Expanded Metal Flat SS	16 sf (16 ea)	100-Large Fab - Basket - 1	S162977

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	28	0
	D4016-3	3	48	0
	D4018-1	2	4	0
	D4018-3	2	12	0
	D4018-5	6	52	0
	D4021-3	1	42	0
	D4035-043	2	10	0
	M304EX0.75-16F	16	717	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



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Container No: S185067



Part: D4018 - 041

Job No: 195020

Serial No/Batch: S185067

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/29/19